

Work Order ID 125027 -2

Friday, October 03, 2014 9:56:44 AM

125027

Page 1

Item ID: D5111-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 10/3/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/3/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 14-10-03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5111

B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 2.540"

64.5

12

0

DAS
20
9-89

14-10-14

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB301

DWG REV: B

FOLIO REV: AA

2- deburr and break all sharp edges

8

0

DAS
20
9-89

14-10-14

30
42

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Friday, October 03, 2014 9:56:44 AM

Item ID: D5111-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 10/3/2014 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 10/3/2014 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 20 9-89 14-10-14
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							JH 2014-10-15
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							CL 14/10/20 8
Outsource process - Anodize	Issue P/O: 26173								
	Black Anodize as per Dwg D5111								
	PRIME AS PER DWG, SEE NOTE #2								

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Friday, October 03, 2014 9:56:44 AM

Item ID: D5111-1 Accept: *N900040100* Setup Start: *NS1*
 Revision ID: Stop: *NS2*
 Item Name: Bracket
 Start Date: 10/3/2014 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 10/3/2014 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start: *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop: *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
170	QC14- Inspect Spray Paint	0.00							
170									
QC	Memo	0.00							
Quality Control									

8X SP14-10-24

(B) 14-10-27 PD

(B) 14-10-27 PD

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Friday, October 03, 2014 9:56:44 AM

Item ID: D5111-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 10/3/2014 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 10/3/2014 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>81/37</u>	0.00							
180						8x			
Packaging	Memo	0.00						DAS 28 9-89	OCT 27 2014
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/10/28 *[Signature]*
[Signature] 4-10-28

Picklist Print

Friday, October 03, 2014 9:56:47 AM

Page 1

Work Order ID: 125027

125027

Parent Item: D5111-1

D5111-1

Parent Item Name: Bracket

Start Date: 10/3/2014

Required Date: 10/3/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV. A NEW ISSUE JFS 14/05/08 VERIFIED BY: RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.250X2.000		Purchased	No			100	f	4,8485	0.212	3			

M7075T6B1 250X2 000

7075-T6 BAR 1.250" X 2.000"

**

DAS

20

9-89

14-10-14

Location

Loc Qty

Loc Code

MAT049

4.8485

m127822

4.8485

2.7

DART AEROSPACE LTD		Work Order: 125 027
Description: Bracket		Part Number: 05111-1
Inspection Dwg: 05111	Rev: B	Page 1 of 1

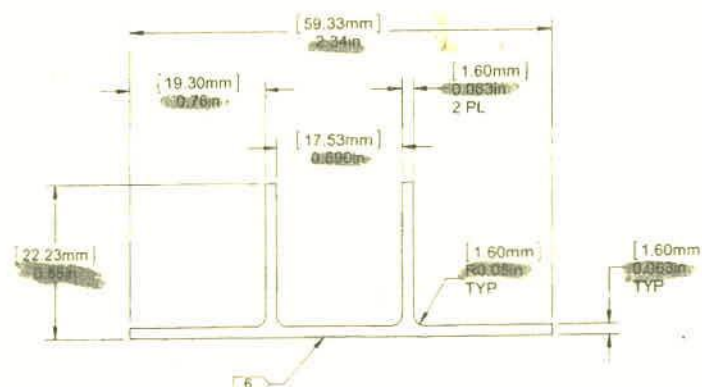
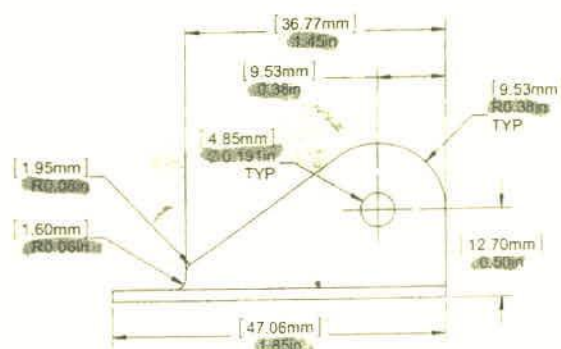
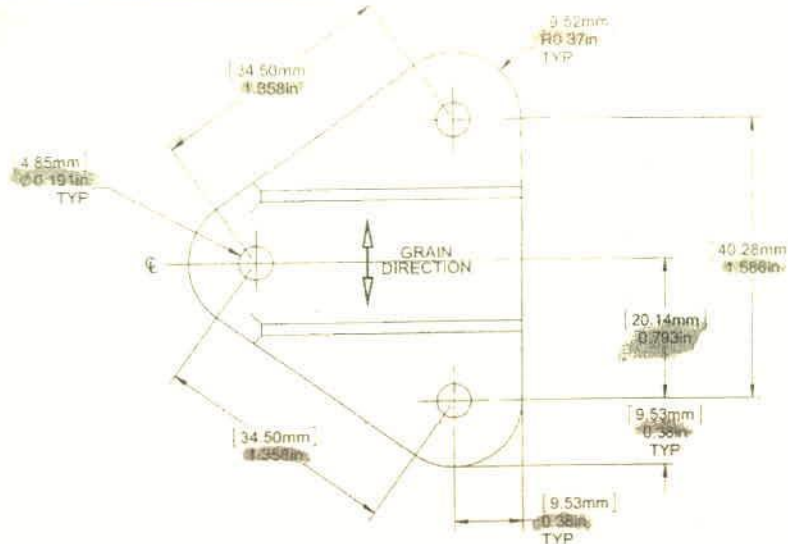
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.358	+/- .005	1.357	✓		SLO8	Vern
Ø .191	+ .005 / - .001	.192	✓		Gauge	PIN
1.358	+/- .005	1.357	✓		SLO8	
.38	+/- .030	.371	✓			
.38	+/- .030	.371	✓			
.793	+/- .010	.790	✓			
1.586	+/- .010	1.584	✓			
R.37	+/- .030	.370	✓		Rad gauge	
1.45	+/- .030	1.441	✓			
.38	+/- .030	.370	✓			
Ø .191	+ .005 / - .001	.192	✓		Gauge PIN	
R.08	+/- .030	.080	✓		Rad gauge	
R.06	+/- .030	.062	✓		Rad gauge	
1.85	+/- .030	1.849	✓			
.50	+/- .030	.497	✓			
R.38	+/- .030	.380	✓		Rad gauge	
2.34	+/- .030	2.330	✓			
.76	+/- .030	.750	✓			
.690	+/- .010	.690	✓			
.063	+/- .010	.062	✓			
.88	+/- .030	.875	✓			
R.06	+/- .030	.062	✓		Rad gauge	
.063	+/- .010	.062	✓			

Measured by: DAS 20 9-89	Audited by: JH	Preliminary Approval:
Date: 14-10-14	Date: 2014-10-15	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D5111-1 BRACKET

NOTES

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187)
OR PER AMS-QQ-A-200/11
REF DART SPEC M7075T6B
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
PRIME IAW MIL-P23377J TYPE I CLASS N, 1-2 MIL MAX, AS PER QSI 005
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5111-1" REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 5.2
- 7) WEIGHT: 0.03 lbs (0.013 kgs)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 125027
14-10-03

RELEASED
2014-06-11

B	REVISE NOTE 6) (2N A8-1)	AK	14.06.05
A	NEW ISSUE	AK	14.04.30
REV	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV B
MFG APPR	JLM	D5111	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR	DS	BRACKET	NTS
DATE	14.06.05	COPYRIGHT © 2014 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE IN THE PUBLIC DOMAIN. IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR FOR ANY OTHER REASON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26173

Purchase Order Date 10/20/2014

PO Print Date 10/21/2014

Page Number: 1 of 3

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

REVISED

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
Line Comments		Promise Date					
Delivery Comments							

1	125027	D5111-1 BRACKET REV. B	10/24/2014		8.00	\$20.00	\$160.
			Yes				
			10/24/2014				

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$160.

2	124942	D5112-3 MOUNTING PLATE REV. A4	10/24/2014		2.00	\$20.00	\$40.
			Yes				
			10/24/2014				

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 1
DYED CLEAR

Line Total: \$40.

Note:

10/21/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63334

Date: 24-Oct-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: D5111-1 BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140692 PO: PO26173	Rev: B	8014-10-24.
1 lot	Part: ASS MOUNTING PLATE ANODIZE AS PER MIL-A-8625 TY II, CLASS 1 2 PCS D5112-3 1 PCS D5112-2 2 PCS D5112-4 1 LOT CHARGE Job: 20140693 PO: PO26173	Rev: A4	Line: 2/3/4
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY			
DATE: 24/10/14			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			

